

Work Order ID 141214

141214

Page 1

Monday, February 01, 2016 11:38:43 AM

Item ID: D2646 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Cap
 Start Date: 2/12/2016 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 2/12/2016 Req'd Qty: 50.00 *50* Customer:

Reference: DAS
 Approvals: Process Plan: 13 9-89 Date: FEB 01 2016 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2646	Rev C								

100 0.00
 100 PURCHASING 50 FEB 01 2016 DAS 13 9-89
 Purchasing Memo 0.00
 Purchasing Issue P/O: 31208 1-Spin as per Dwg D2646 2-Material release
 note required
 Vendor: Sieg's Manufacturing

110 0.00
 110 Receive & Inspect for Damage & Mat'l Certs 50x 16-02-18
 Packaging Memo 0.02
 Packaging Ensure Material Release Note is attached

120 0.00
 120 QC6- Inspect dimensions to drawing
 QC Memo 0.00
 Quality Control

(50) FEB 29 2016

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Start Date: 2/12/2016 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 2/12/2016 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Small Fab

Small Fab

Memo

0.04

Small Fab

1-Drill using DT8026 as per Dwg D2646.2-Open holes to .297 as per Dwg
D2646.3-Deburr

50

FF

140

0.00

140

QC5- Inspect part completeness to step on W/O

QC

Memo

0.02

Quality Control

50

DAS
38
9-88

FEB 22 2016

150

0.00

150

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.02

Hand Finishing

x50 d ll 16/02/15

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Item ID: D2646 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Aft Cap
 Start Date: 2/12/2016 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 2/12/2016 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 133962</i> Memo START TIME: <i>11:20</i> <i>820</i> FINISH TIME: <i>11:50</i>	0.00 0.00				<i>34 34</i>	<i>0</i>	<i>16-02-25</i>	<i>34 34</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<i>x34</i>	<i>d</i>	<i>16/02/25</i>	<i>DAS 15 4-89</i>
180 *180* Small Fab Small Fab Small Fab	Small Fab Memo Install inserts as per Dwg D2646	0.00 0.03				<i>x34</i>	<i>d</i>	<i>16/02/25</i>	

Work Order ID 141214

Monday, February 01, 2016 11:38:43 AM

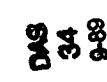
141214

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Item ID: D2646 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Cap
Start Date: 2/12/2016 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 2/12/2016 Req'd Qty: 50.00 ***50*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	 QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				34	0	16-02-25	
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>EP-001</u>  Memo LOCATION : FP001	0.00 0.01				X 34	0	all velco	
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.08				ML5		FEB 26 2016	

ML5 FEB 26 2016

Picklist Print

Monday, February 01, 2016 11:38:41 AM

Page 1

Work Order ID: 141214

141214

Parent Item: D2646

D2646

Parent Item Name: Aft Cap

Start Date: 2/12/2016

Required Date: 2/12/2016

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP: G05.08.22Hole size revised in Step 5KJ/JLM

IPP Rev:H Changed Inserts 07-02-19 JLM

IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130

AELS8-1032-130

Purchased

No

110

Each

2,630.000

2

~~100~~ 68

AI S7-1032-130

**

Rivnut

Location

Loc Qty

Loc Code

FG

100

M128649

100

FP001

1207

M128649

1207

st549

1323

M128649

1323

D2646P

Purchased

No

180

Each

0.0000

1

50

D2646P

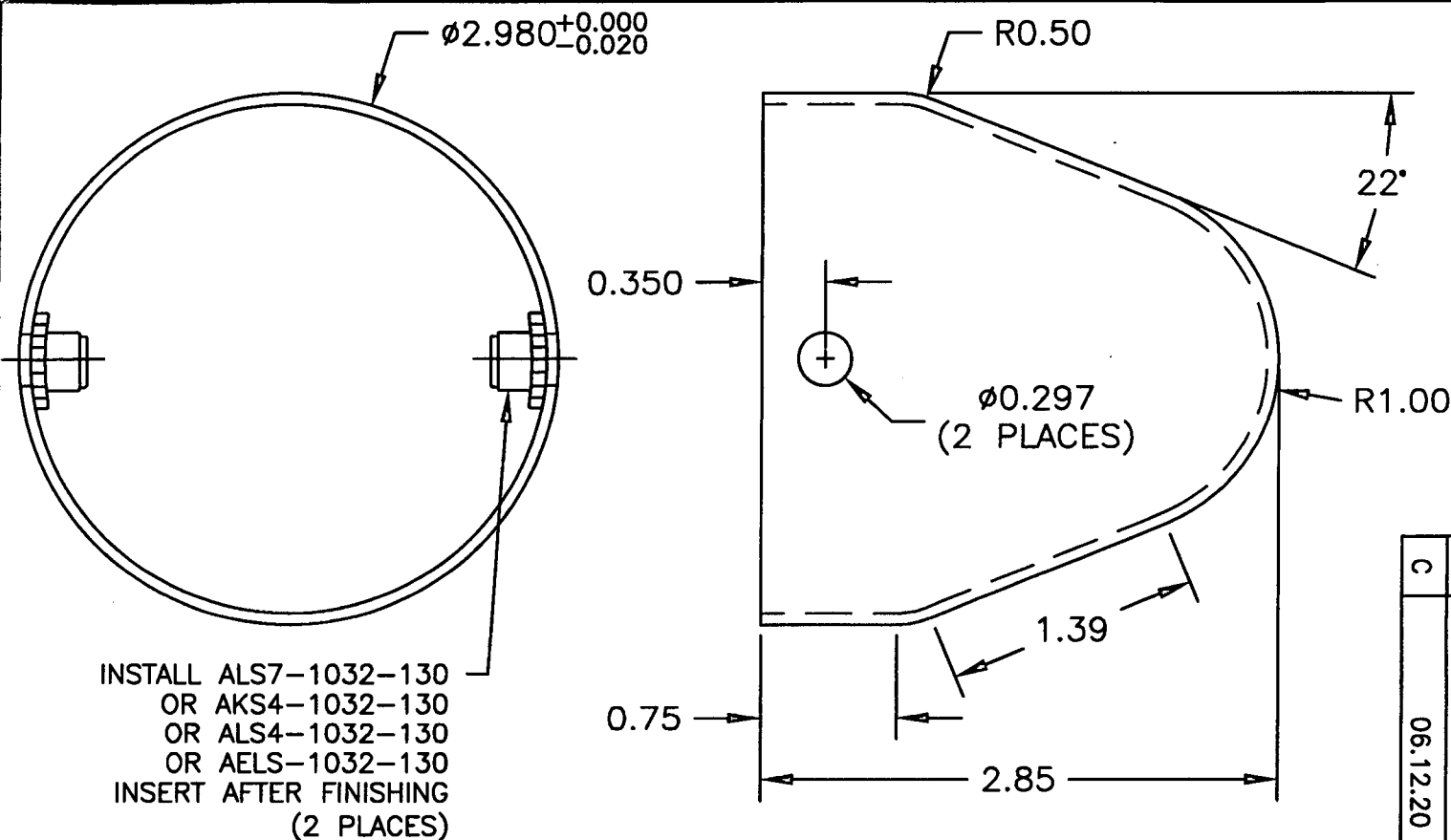
**

Aft Cap

50x 8016-02-18



DESIGN	DS	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	PORT HADLOCK, WA
DATE	06.12.20	DRAWING NO.	D2646
		TITLE	AFT CAP
		SCALE	1:1
A		97.03.25	NEW ISSUE
B		05.04.01	CHANGE TO CLOSED INSERTS
C		06.12.20	CHANGE TO OPEN ENDED INSERTS



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-O 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
07.02.12

DAS
13
00

FEB 01 2016

W10:141214



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31208**

Purchase Order Date 2/1/2016 11:40:28 AM

PO Print Date 2/1/2016

Page Number 1 of 2

Order From :

VC-SIE001

SIEG'S MANUFACTURING LTD.
6236 - 205 STREET
LANGLEY, BC V2Y 1N7
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
FEB 01 2016

Contact Name

Vendor Phone 604 530 7455

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2646P ✓ AS PER DWG D2646 REV. C B141214	Aft Cap	2/18/2016 Yes 2/18/2016		50.00 Each	\$6.70	\$335.00
Line Total:							\$335.00
3	71401-45	PROCUREMENT QUALITY CLAUSES	2/18/2016 No 2/18/2016		1.00	\$0.00	\$0.00
Procurement Quality Clauses							
A005 right of entry							
A012 chemical and physical test report							
A016 personnel qualification							
A017 raw material identification (as applicable)							
A026 certification of material conformance							
A041 quality management system							
A042 dart notification by supplier							
A043 retention of quality documents							

Note:

2/1/2016



Sieg's Manufacturing Ltd.

Quality Metal Spinning & Metal Fabricating
6236 205 Street, Langley, BC, Canada V2Y 1N7
Phone: (604)530 7455 Fax: (604)530-7490
www.siegsmf.com

Packing Slip

Packing Slip No.: 46440
Date: 02/16/2016
Page: 1

Sold to:		Ship to:	
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	
Order No.: 31208		Sold By: LOWEY, ARLA	
Shipped By:		Ship Date:	
Tracking No.:			

Item No.	Unit	Description	Quantity	Backorder quantity
D2446P ✓	Each	Aft Cap	50	
Sp/6-02-18				
Comment:				



Sieg's Manufacturing Ltd.

6236 205 Street Langley, B.C. Canada V2Y 1N7

Ph#: (604)530-7455 fax#: (604)530-7490

arla@siegsnfg.com

INSPECTION REPORT

Date: February 16, 2016

Customer: Dart Areospace

Packing Slip: 46440

Part#:	Quantity	Material	Check holes	Insp. By.
D2646 ✓	50 ✓	14g 1100	N/a	AL

Notes:

Material Certification Attached: YES

SP/6-02-18

ThyssenKrupp Materials NA
Copper and Brass Sales Division
19044 95A Avenue
SURREY BC V4N 4P2
Tel.: +16048823493 Fax: +16048820686



Order number	Ord-pos	Del-pos	Part description
Customer PO	PO date	Quantity	Customer Part
MTR header	MTR type	Search criteria	Heat lot
			Sample number
C8A/1401788868	000020	900001	1100 Aluminum - O Sheet 0.06300 X Width
1514	12/18/2013	74 ST	
Att_001.PDF	NCAP	930230267220130003	11A711
C8A/1401788868	000020	900002	1100 Aluminum - O Sheet 0.06300 X Width
1514	12/18/2013	26 ST	
Att_002.PDF	NCAP	930235185120130004	11B224

Delivery number
2402875712
Date
12/19/2013

SIEGS MANUFACTURING LTD.
6236 205 ST
LANGLEY V2Y 1N7
CANADA



Skana Aluminum Co
Rolling Mill - Certified Metal
Certification of Properties and Analysis

Physical test: 11B224 Aluminum Alloy: 1100 Temper: -O- Thickness: .0630

Tested For: Copper and Brass Sales

6156 PO No: 5400200310-R01

Chemical	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others	Al
Min Range	..		0.05	..	..	..	..	..	..		
Max Range	.95 Si	+ Fe	0.20	0.05	..	..	..	0.1	..	0.05	

Coil Ref. No.	1	2	3	4	5						
Tensile Strength KSI	14.10	14.06	14.04	14.06	14.14						
Yield Strength KSI	6.29	5.14	5.07	5.07	4.93						
% Elong. in 2 in.	30.80	30.40	30.70	31.30	32.30						

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Remarks: Tested By: RJD

Certified Date: 21 Nov 2013

Certified By
Lab Manager

[Signature]

RJD .063 X 48.000 MF 5/5

ITEM # ALFLR01243

MEETS/EXCEEDS ASTM B209-10 SPEC

BLANKS: COILS TO PRESSROOM

Thursday, November 21, 2013

Melted/Manufactured in USA

QF 824-1-1

Page 1 of 1

From: Copper and Brass Sales CA

Cust. SIEGS MANUFACTURING LTD.

Del.: 2402875712

CstAr

CstOr 1514

Wgt.: 1,109.542 LB

Date 12/19/2013

[Signature]

Skana Aluminum Company

Rolling Mill - Certified Metal

Certification of Properties and Analysis

Physical test: 11A711 Aluminum Alloy: 1100 Temper: -O- Thickness: .0630

Tested For: Copper and Brass Sales 6156 PO No: 5400197413-R01

Chemical	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others	Al
Min Range	..		0.05	..	..	..	..	..	..		
Max Range	.95 Si	+ Fe	0.20	0.05	..	..	..	0.1	..	0.05	

1	13.28	4.34	31.80	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.44	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

2	13.38	4.25	31.90	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.43	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

3	13.44	4.46	32.70	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.43	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

4	13.55	4.68	31.40	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.44	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

5	13.31	4.47	30.30	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.43	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

Remarks: Tested By: RJD

Certified Date: 10 Oct 2013

Certified By:
Lab Manager

Kenna Clifton

RJD .063 X 48.000 MF 5/5

ITEM # ALFLR01243

MEETS/EXCEEDS ASTM B209-10 SPEC

BLANKS: COILS TO PRESSROOM

Thursday, October 10, 2013

Melted/Manufactured in USA QF 824-1-2

Page 1 of 2

From: Copper and Brass Sales CA

Cust. SIEGS MANUFACTURING LTD.

Del.: 2402875712

CstAr

CstOr 1514

Wgt.: 3,157.927 LB

Date 12/19/2013

John R. Jacobetti